

Work Order ID 162647***162647***

Page 1

Tuesday, June 06, 2017 10:44:45 AM

Item ID: D3001-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 6/7/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/9/2017 Req'd Qty: 2.00 ***2*** Customer:

Reference:

DAS

13

9-89

Approvals: Process Plan: Date: JUN 06 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3001	Rev B
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.07

FLOW CNC Waterjet

1-Cut as per Dwg D3001

Dwg Rev: 13Prog Rev: 13

2-Deburr if necessary

②

SC 17/06/06

DAS

20

9-89

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

②

SC 17/06/06

DAS

20

9-89

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Page 2

Item ID: D3001-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 6/7/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.04

Quality Control

DAS
38
6-89
JUN 06 2017

130

Small Fab

0.00

130

Small Fab

Memo

0.10

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 006
2-Deburr.DAS
38
6-89
17/06/06

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.04

Quality Control

DAS
38
6-89
JUN 07 2017

162647

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

150	Chemical Conversion Coat per QSI005 4.1	0.00	
150			
HandFinish	Memo	0.14	
Hand Finishing			BEB

160	QC7-Inspect Chemical Conversion Coat	0.00	
160			DAS
QC			16
	Memo	0.02	9-89
Quality Control			(42) _____ 17/06/09

170	Identify as per dwg & Stock Location: <u>5483</u>	0.00	JUN 09 2017 <u>2</u> <u>9-89</u>
170			
Packaging	Memo	0.02	
Packaging			

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Item ID: D3001-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 6/7/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/9/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.20

Quality Control



17/6/13 dg

 JUN 09 2017

Picklist Print

Tuesday, June 06, 2017 10:44:43 AM

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T

Work Order ID: 162647

162647

Parent Item: D3001-1

D3001-1

Parent Item Name: Doubler

Start Date: 6/7/2017

Required Date: 6/9/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A01.03.22New IssueEC
IPP rev.B added scuffing NCR 061 EC
IPP Rev:C Now On Waterjet 07-12-13 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

71.4687

0.7083

1.491158

M5052H32S 040

**

5052-H32 .040 Sheet

SC/17/06/06
DAS
20
9-89

Location

Loc Qty

Loc Code

MAT

7.7

m135512

7.7

MAT022

11.4

m134774

11.4

MAT023

52.368684

m1342217

1.313684

m134617

2.1

m136102

2.8

m136897

14.155

m137599

32

1.5

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
90	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
J. J. H.	[Signature]	D3001
DATE		TITLE
06.10.06		DOUBLER
A	01.03.21	NEW ISSUE
B	06.10.06	ADD BONDING PREP NOTE
		REV. B
		SHEET 1 OF 1
		SCALE
		1:5

RELEASE

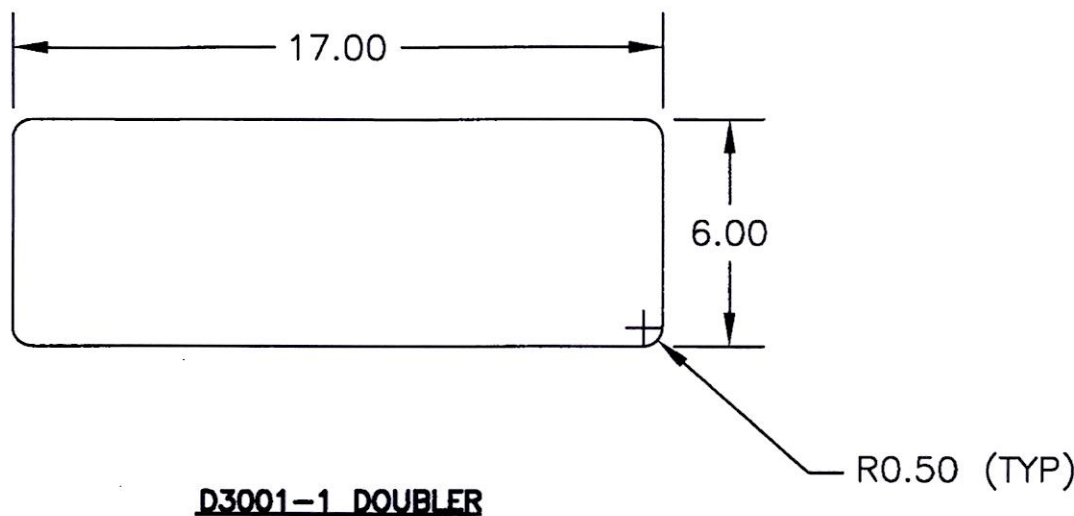
06.11.13

DAS
13
9-89

JUN 0 6 2017

JUN 0 6 2017

W/O. 162647



NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.1
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX

